

Work Order ID 70022

Wednesday, May 25, 2011 12:37:27 PM



Page 1

Item ID: D3393-041

Accept



Setup Start



Revision ID:

Item Name: Battery Lock Assembly

Stop



Start Date: 5/25/2011 Start Qty: 8.00



Cust Item ID:

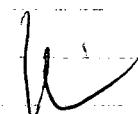
Required Date: 5/27/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:



Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours
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Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3393	Rev A

100 0.00



Small Fab

Small Fab Memo 0.00
1-Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest. 2-Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-5. 3-Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten

7

PJO

SB 110528

110 0.00



Large Fab

Large Fab Memo 0.00
Tack Weld lock shaft to flat cam of a Max 1/8" Long. Qty Part Number
Description Batch!! A/RN/A SS Rod 115928

GL 11.05.27 7

120 0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC Memo 0.00

Quality Control

AA 11.05.27 7

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3393-041 PAR #: N/A Fault Category: Supplier m/Master NCR: Yes No DQA: A Date: 11.06.01
 11/05/01 Resolution: Disposition: QA: N/C Closed: CK Date: 11/06/01

NCR: 70022		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/05/01	100	I key for kee stapler didn't turn + I wasn't good R.C. Supplier / Purch. Product.	4.05.26	Scrap + destroy D3393-1	S 11/05/26	S 11/05/30	11/05/26 Q81092	S 11/05/30

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 5/27/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

130



Operation
Description

Small Fab

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

E/S 1/105/27

Small Fab

Memo

0.00

Small Fab

Apply Crazy Glue to cap and press into Body 19567K21
Batch: M1160244

140



QC5- Inspect part completeness to step on W/O

0.00

8 w/lost 30

QC

Quality Control

0.00

(X7)

150



Identify as per dwg & Stock Location: 487

0.00

Packaging

Memo

0.00

Packaging

11/130 C70 SF

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Accept



Setup Start



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Stop



Start Date: 5/25/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 5/27/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

QC

Quality Control

Memo

0.00

160
QC

MF
11-05-30

Picklist Print

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Work Order ID: 70022



Parent Item: D3393-041



Parent Item Name: Battery Lock Assembly

Start Date: 5/25/2011

Required Date: 5/27/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 05-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

5/16WC



SS Flat Washer 5/16 FW516S1

Purchased

No

100

Each

3,379.000 2



SB

11/05/30

Location	Loc Qty	Loc Code
----------	---------	----------

st376 2000 _____

117332 2000 _____

ST377 1379 _____

115072 100 _____

115174 57 _____

116643 1222 _____

9567K21



Polyetheline Cap

Purchased

No

100

Each

41.0000 2



SB

11/05/30

Location	Loc Qty	Loc Code
----------	---------	----------

ST380 41 _____

110822 41 _____

D2728-7



Dart Logo label

Manufactured

No

100

Each

0.0000 0



TY

SB 11/05/30

D3373-1



Cam Lock

Manufactured

No

100

Each

17.0000 1



SB

11/05/30

Location	Loc Qty	Loc Code
----------	---------	----------

ST049 17 _____

58463 17 _____

7

Picklist Print

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Work Order ID: 70022



Parent Item: D3393-041



Parent Item Name: Battery Lock Assembly

Start Date: 5/25/2011

Required Date: 5/27/2011

Start Qty: 8.00

Required Qty: 8.00

D3393-1



Manufactured

No

100

Each

10.0000

1

8



SB 1105 / 30

Battery Lock Casing

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST487	10	
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62953	10	
-------	----	--

D3393-3



Manufactured

No

140

Each

7.0000

1

8



SB 1105 / 30

Cam Lock Shaft

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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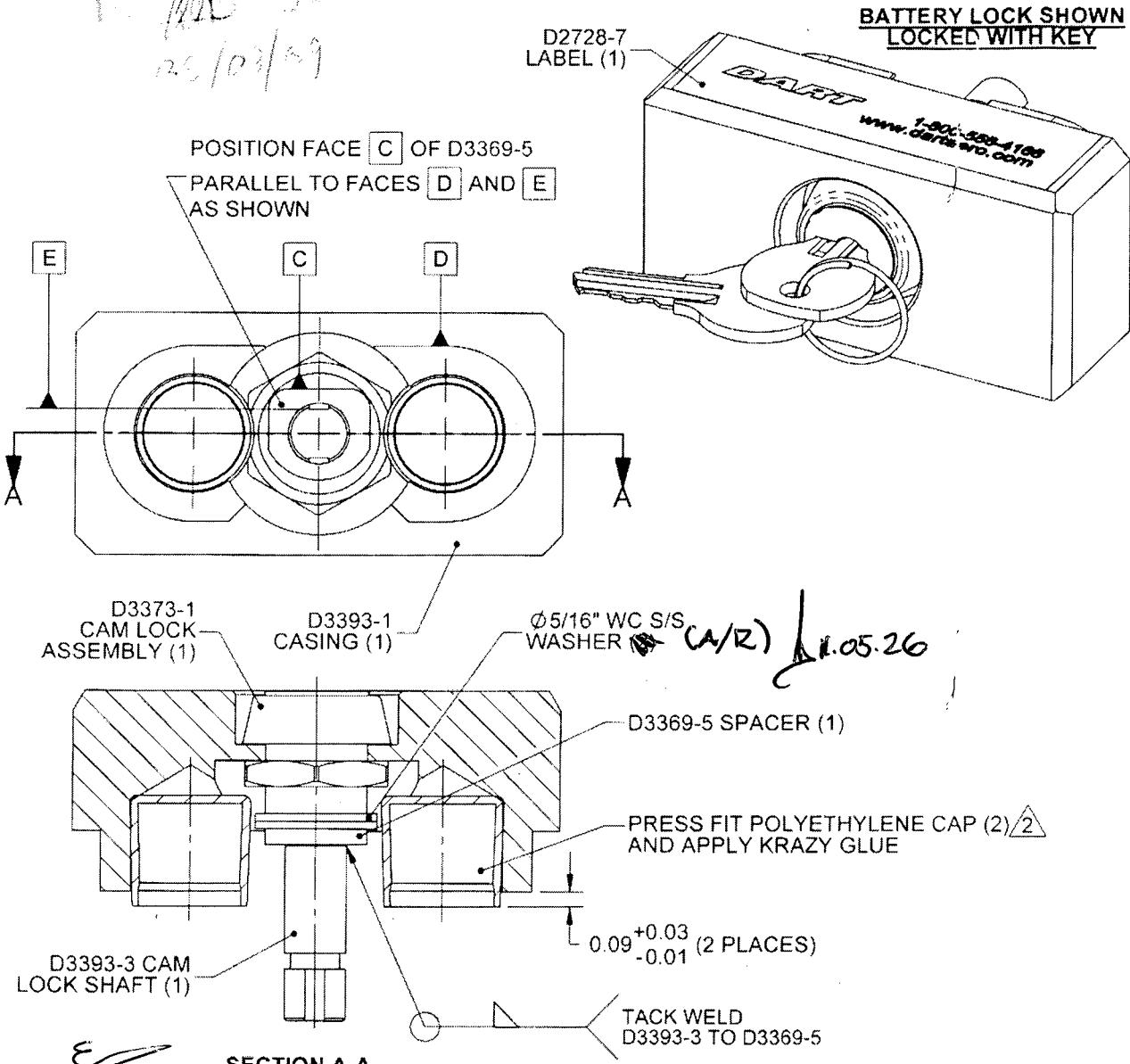
ST052	7	
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61947	7	
-------	---	--



DESIGN <i>b3</i>	DRAWN BY <i>b3</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>TT</i>	APPROVED <i>AK</i>	DRAWING NO. D3393	REV. A	SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1	
A	05.02.08	NEW ISSUE		

2008-02-05
2008/02/05



D3393-041 BATTERY LOCK ASSEMBLY

NOTES:

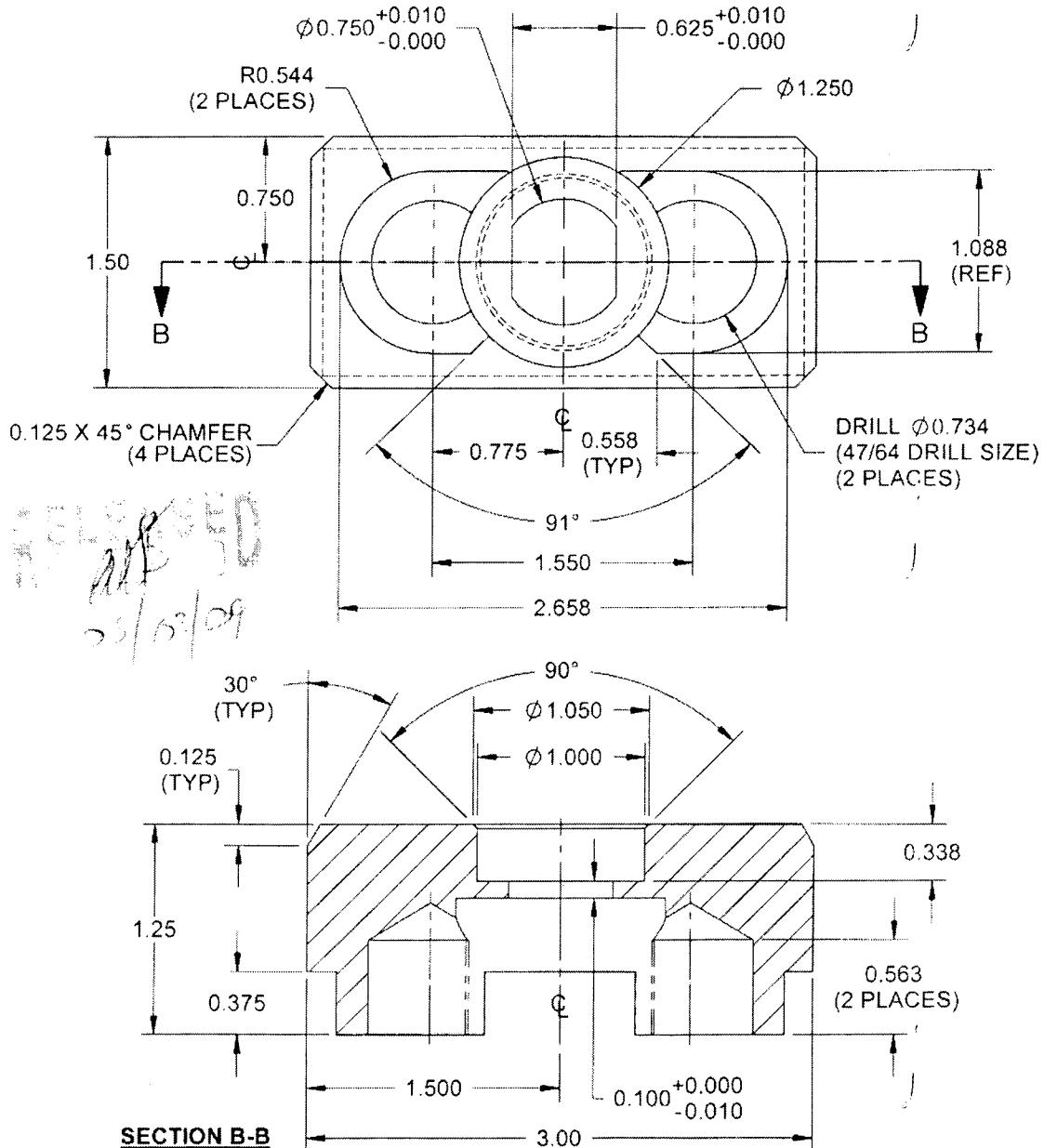
- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMaster-Carr, P/N 9567K21

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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE	05.02.09	TITLE	SHEET 2 OF 3 BATTERY LOCK 1:1



D3393-1 CASING

NOTES:

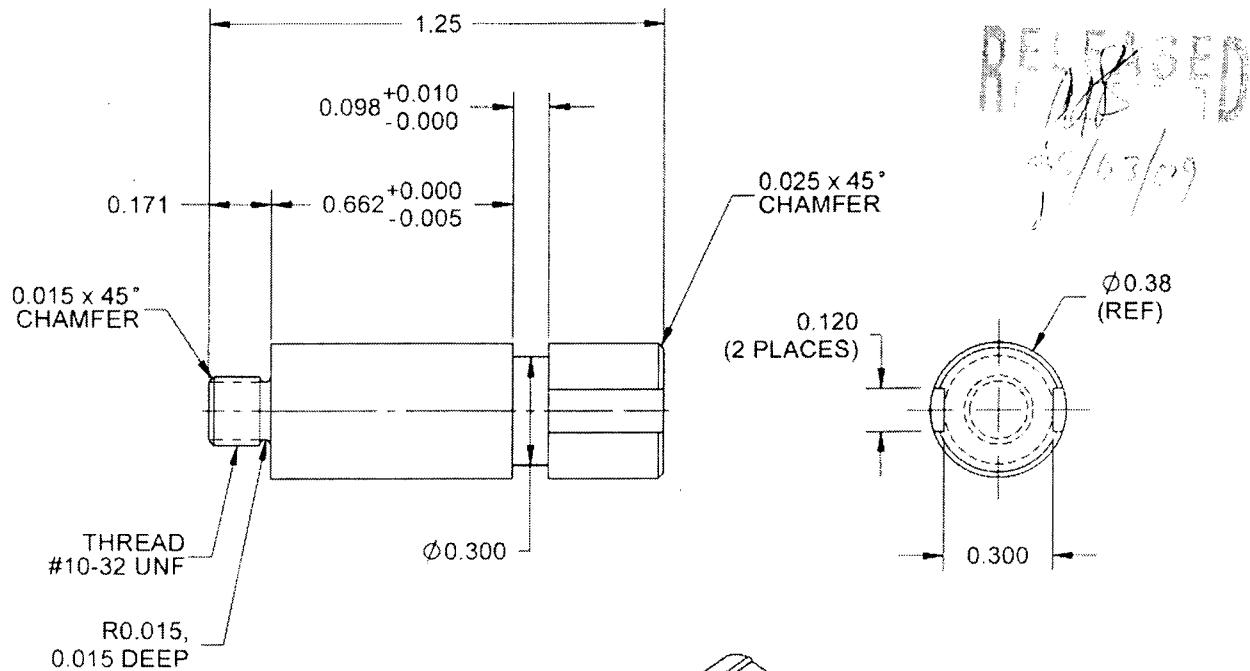
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART

DESIGN <i>b3</i>	DRAWN BY <i>b3</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>TT</i>	APPROVED <i>PL</i>	DRAWING NO. D3393	REV. A SHEET 3 OF 3
DATE 05.02.09	TITLE BATTERY LOCK	SCALE 2:1	



D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010